

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006757**Date Inspected:** 08-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/08/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4, Japan Steel Works, Muroran, Hokkaido, Japan.

West Deviation Saddles:

W2E3 - Section has been laid down to weld 1G (Flat) weld of Cast stem to Plate stem, joint E3S-2U. Welders T. Kawakami 08-5079 and Y. Maeyama 94-5234 were Flux Core Arc Welding with 1.6mm, TM95 wire, approximately 60% complete. After witnessing parameter verification, QAI noted shop weld log (layer record) as having wrong "Side" having been recorded for all bead/layers. Weld beads were inadvertently labeled as deposited on side 2 vs 1. QC CWI Makhmud Ashadi brought disparity to the attention of the Weld Supervisor and immediate correction was made.

W2W1 - Welder D. Kito 08-5175 Flux Core Arc Welding (FCAW) of temporary lifting lugs to buttering on casting, at ends outside trough. Mr Sadakawa 06-2929 was in process welding joint W1S-2U, plate stem to cast stem, root with E9018M 4mm electrode, per procedure SJ-3011-5, and within contract document specifications.

W2W2 - Plate rib being welded to Plate stem, joint W2Y-6V by T. Watanabe 08-5153 using procedure SJ-3011-3. Plate rib to plate base, joint W2Y-13L, is in process by welder M. Kashiwada 08-2008 per SJ-3011-2, both welders are using Flux Core Arc weld (FCAW) process, 1.6mm TM95 weld wire. Cast section awaiting transfer from Foundry.

W2W3 - Plates are being fit up with tacks, observed piece mark's 6-7,-8,-9,-10,-11,-12 having been fit up and tacked. Tacks were of proper length and no visual cracking noted at this time.

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Tower Saddles:

T1-3 - Welder, T.Ohta 08-2017 was joining lifting lug per shop procedure to buttering on cast rib of side 1 of tower saddle using 4mm 7016 electrode, in the 3G position. QC CWI monitored process during QAI observation.

Observed bend test of of four (4) welders, FCAW 1G position, welder ID's of 08-5173, 08-5174, 08-5175, 08-5176. Test conducted by Japan Steel Works testing laboratory under the witness of QC CWI Makhmud Ashadi.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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| Inspected By: | Brcic,Michael | Quality Assurance Inspector |
| Reviewed By: | Lanz,Joe | QA Reviewer |
